

Date: Tuesday, 20/01/2009 2:32:01 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 44958  
 Estimate Number : 13745  
 P.O. Number :  
 This Issue : 20/01/2009 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : SMALL /MED FAB  
 Previous Run :  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev:A 09-04-20 as per prelim issue DD verified by:ec

Drawing Name : BASE  
 Part Number : D38701  
 Drawing Number : D3870 PRELIM  
 Project Number : N/A  
 Drawing Revision : PRELIM  
 Material :  
 Due Date : 27/01/2009



Qty: 8 Um: Each

*+1 for jig*

## Additional Product

Job Number:



**PRELIMINARY ISSUE**

Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0250X06000 6061-T6 Bar .250 x 6.00



Comment: Qty.: 0.0906 f(s)/Unit Total: 0.7249 f(s)  
 6061-T6 Bar .250 x 6.00  
 batch: 109028 1B 9-1-21

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3870  
 Dwg Rev: PRE  
 Prog Rev: Lim

1B 9-1-21

2-Deburr edges and holes if necessary

*M-f*

(H)

09/01/21

(10x)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1B 9-1-21

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

EP' TESTING  
3/AL

09-01-21

(10x)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart P/N and B/N using a permanent fine point marker, then Stock  
 Location: \_\_\_\_\_

09-01-21 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: BASE

Job Number: 44958

Part Number: D38701

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/17

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-28

COGNITIVE RECALL  
EFFECTIVE 09-01-21 AUTH 1  
RELEASED 1 DATE 09-02-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## FIRST ARTICLE INSPECTION CHECKLIST

**x | Prototype**

Measured by: <i>KB</i>	Audited by: <i>↓</i>	Prototype Approval:
Date: <i>9-1-21</i>	Date: <i>09.01.21</i>	Date: <i>/</i>

H-1 FORMS 510 Family Assurance approved OAI/FAI revD

8

7

6

5

4

3

2

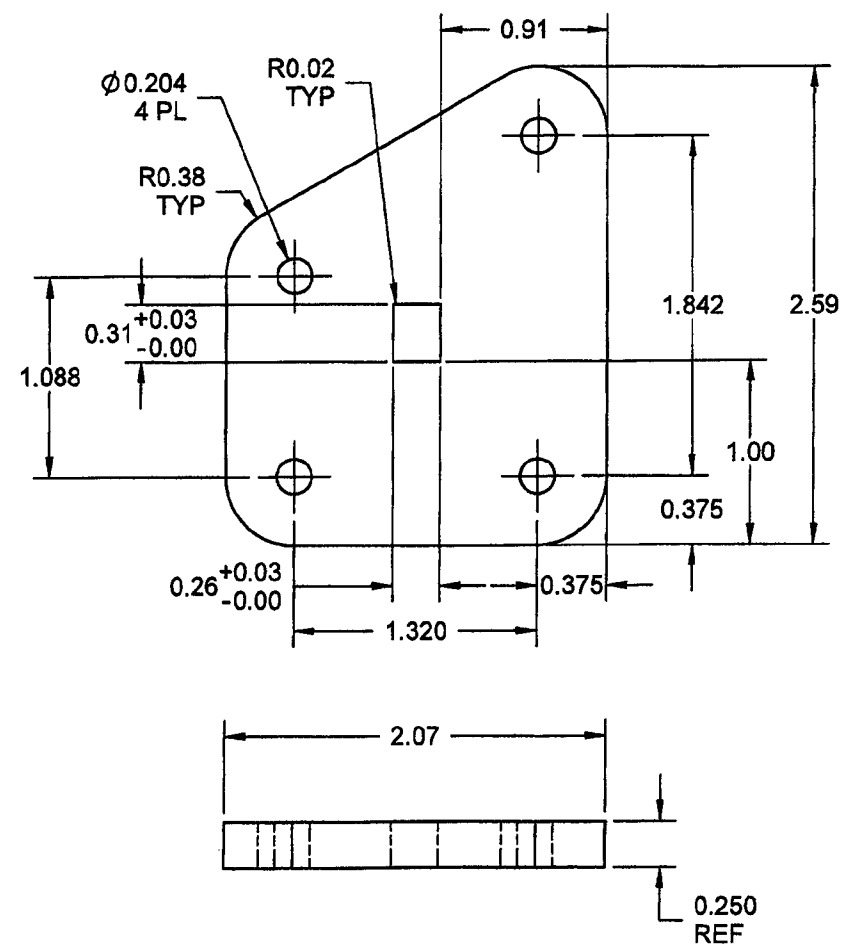
1

D

C

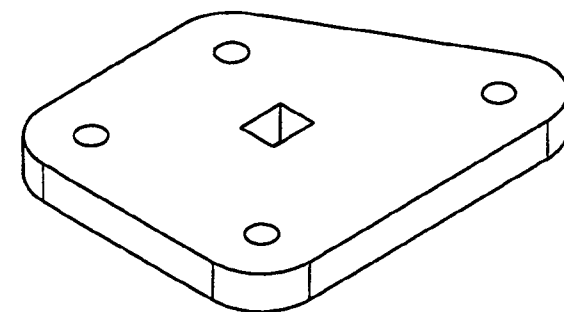
B

A



D3870-1 BASE/

+1 fig



D

C

B

A

## NOTES:

1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.25 THICK PER AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.250)

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

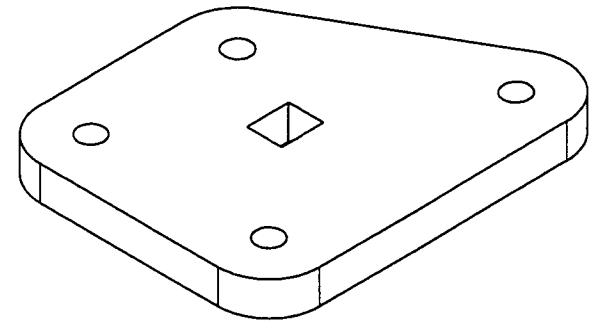
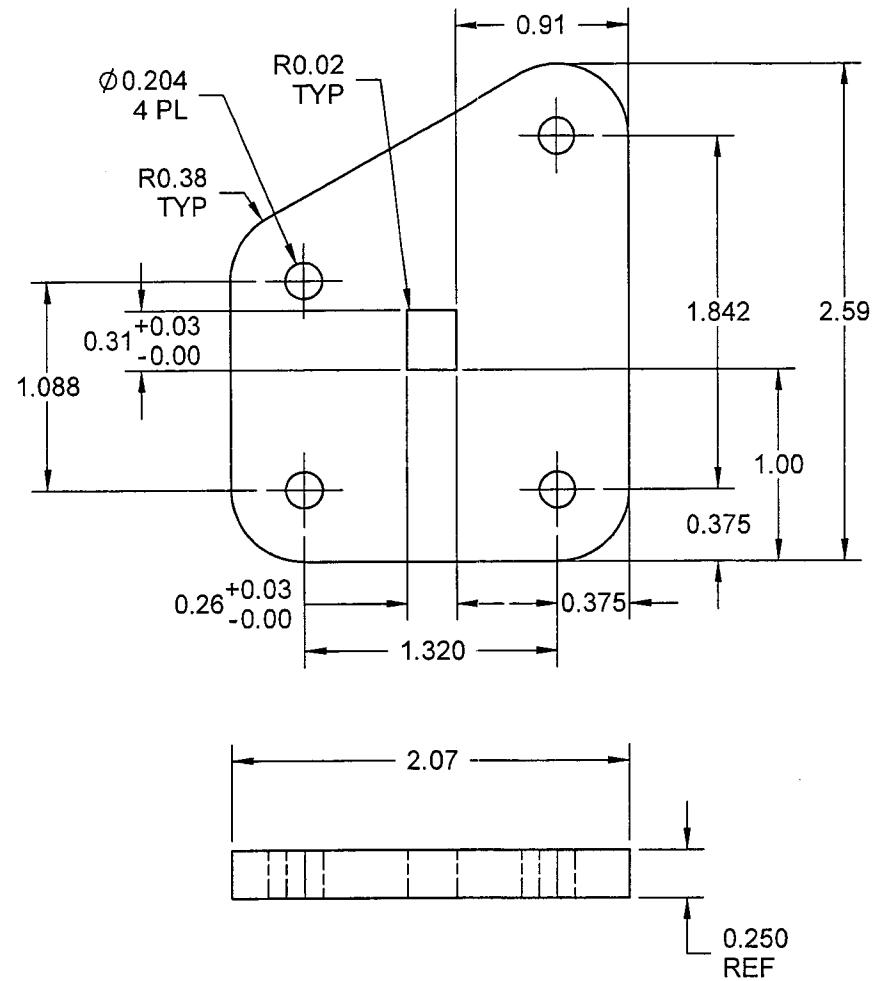
6) IDENTIFICATION: N/A

7) WEIGHT: 0.04 lbs

PRELIMINARY ISSUE  
09/01/15

44958

DESIGN	<del>DES</del>	<b>DART AEROSPACE LTD</b>	
DRAWN	<del>DES</del>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>DES</del>	DRAWING NO.	REV. A
MFG. APPR.	<del>DES</del>	D3870	SHEET 3 OF 5
APPROVED	<del>DES</del>	TITLE	SCALE
DE APPR.	<del>DES</del>	MOUNT	NTS
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**D3870-1 BASE**

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- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

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44958  
RELEASED  
09/01/11